

-022 Blue

Dart Aerospace Ltd.

38

Date: Tuesday, 8/21/2007 2:01:19 PM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206L /407 STEP ASSY, RH
Job Number : 34130A
Estimate Number : 11703
P.O. Number : N/A Part Number : D2724042
This Issue : 8/21/2007 S.O. No. : N/A Drawing Number : D2724 REVC
Prsht Rev. : NC Project Number : N/A
First Issue : N/A Type : LARGE FAB ASSY Drawing Revision : C
Previous Run : 33757A Material : PL
Written By : Due Date : 9/20/2007 Qty: 3 Um: Each
Checked & Approved By : 07.08.21
Comment : Est Rev:E As Per Ecn 766 06-01-06 JLM

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D2622120C Extrusion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	B32858

Check Material for any Dents or Defects

A.M 07.09.10 3

2.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-2 using D2622 extrusion as per Dwg D2724
Deburr and bevel ends for welding

A.M 07.09.10 3

3.0 D2734 206 Step Endplate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	B33861

P.E. 07.09.11

4.0 D34581 PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	B34179

P.E. 07.09.11

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 2:01:19 PM
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 34130A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

PLATE



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3458-3

Plate

334180

PL 07.09.11

3

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT followed by Jig

DT (One End Only)

A/R AL ROD Batch: M103794

M104721

Grind end cap welds flush

PL 07.09.11

3

U.M 07.09.13

3

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

10/09/13 (3)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

07/04/13 (3 RM)

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

U.M 07.09.13

3

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M-L 07/09/17

(3X)

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

PL 07.09.18

3

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 2:01:19 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 34130A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig
DT
A/R AL ROD Batch: M103794

PE 07-09-18 3

Grind end plate flush.

a.m 07.09.20

3

12.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 07-09-20 (3)

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Er 07/09/20 (43RH)

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

3 RH

Touch up Alodine

BR

07-09-20

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment: Issue P.O. 4650
Atelier Debosselage

C207/09/21

3

Spray Paint Delfleet Blue
Clear with Delfleet

Er 7/9/24

16.0

QC14

INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

Er 07/09/25 (3RH)

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 54.4

m/05694

Er 07/09/25 (3)

18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

7/9/24 50

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: LD Date: 07/15/20
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 2:01:19 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, RH

Job Number: 34130A

Part Number: D2724042

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

34/30

8/9/07

20.0

QC21

FINAL INSPECTION/W/O RELEASE



(3)

Comment: FINAL INSPECTION/W/O RELEASE

12/07/07

Job Completion



U 07-09-26

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

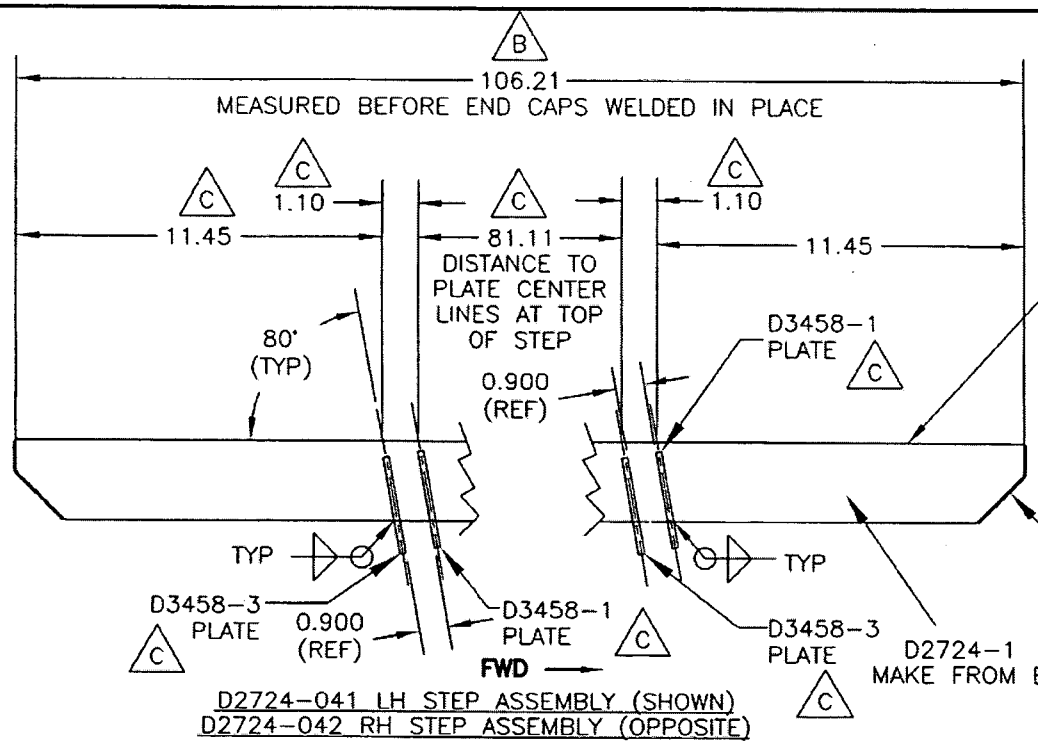
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng		Sign & Date			

NOTE: Date & initial all entries

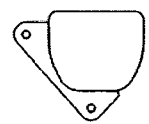


RELEASED
05.11.14

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



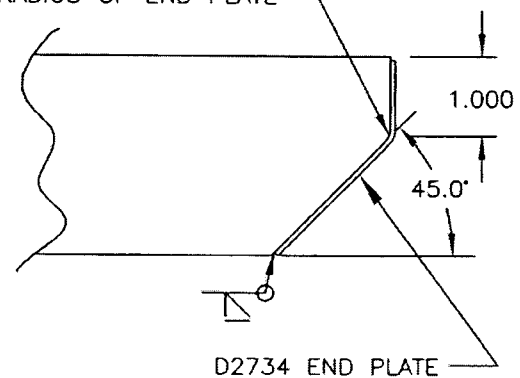
APPLY BLACK
ANTI-SKID ON
TOP SURFACE
TO BOTTOM
OF TOP RADIUS



REFER TO STEP
END DETAIL

D2724-1
MAKE FROM EXTRUSION D2622-107

ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D2724-041	LH STEP ASSEMBLY
	X	D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 34130A

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.	
KE	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. C
		D2724	SHEET 1 OF 1
DATE		TITLE	SCALE
05.09.19		206L/407 STEP ASSEMBLY	NTS
A	97.12.04	NEW ISSUE	
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES	
C	05.09.19	RE-DESIGN, ADD D3458-1/-3	

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